

Work Order ID **77361*****77361***

Page 1

December-06-11 10:29:37 AM

Item ID: D3199-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket, Fwd LH
Start Date: 06/12/2011 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 13/12/2011 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: 11/12/06 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3199	E								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut as per Dwg D3199								
304 .0412	Dwg Rev: <u>5</u>								
	Prog Rev: <u>5</u>								
	Deburr if required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

B11-12-1218B11-12-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		8 11/12/12		(18)			PO
130 *130* Brake NC Brake NC	Bend as per dwg Small Fab Memo	0.00 0.00		SP 11/12/19		(17)			
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8 11/12/20		(17)			3

Dart Aerospace Ltd

W/O: 77361		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3199-3 PAR #: Fault Category: Small Fab NCR: Yes No DQA: Ant Date: 12/01/03
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: CK Date: 12/01/03

NCR: 11-1087		WORK ORDER NON-CONFORMANCE (NCR) # 10:96						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/12/03	120	1 pin scrap 1 side to short when cut on water jet R-C Process	S 11/12/03 Q52042	Scrap - destroy	S 11/12/03	S 11/12/03	S 11/12/03 Q52042	S 11/12/03

NOTE: Date & initial all entries

Work Order ID 77361

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Page 3

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket, Fwd LH

Start Date: 06/12/2011 Start Qty: 5.00

5

Cust Item ID:

Required Date: 13/12/2011 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

150

Powdercoat

Powder Coating

Memo

START TIME: 1:15

OVEN TEMPERATURE: 320 °F

FINISH TIME: 1:45

0.00

160

QC3- Inspect Part Finish

0.00

160

QC

Quality Control

Memo

0.00

170

Identify as per dwg & Stock Location 236B

0.00

170

Packaging

Packaging

Memo

0.00

17 X 8 M / 11/12/21

12 of 24 11/12/21
counted

11/12/22 172

W/O:		WORK ORDER CHANGES					
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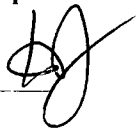
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QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

11/12/23 
WVF
11-12-20

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

December-06-11 10:29:41 AM

Page 1

Work Order ID: 77361

77361

Parent Item: D3199-3

D3199-3

Parent Item Name: Bracket, Fwd LH

Start Date: 06/12/2011

Required Date: 13/12/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP RevA: RevC-prelim DD verified by:EC
11.03.31 as per ecn 11-531 DD ver:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	261.8795	0.1673	0.880526			
M304S20GA									**				
304/316.040 Sheet													

4.363

18-12-72

Location

MAT020

Loc Qty

261.8795

Loc Code

116623

0.2

117550

4.363

117933

27.3442

118400

25.6723

118964

36.5

119346

167.8

18

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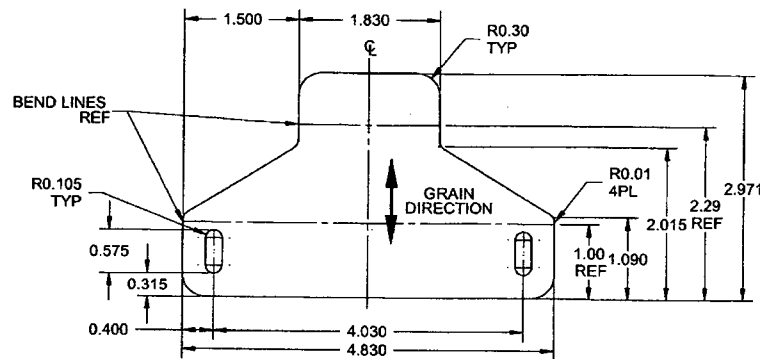
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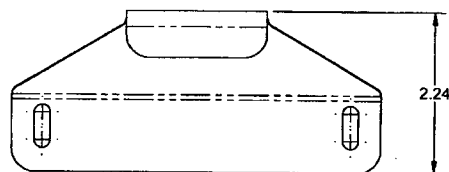
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77361

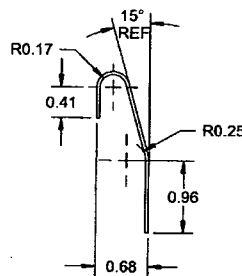
M.L.J.
11/12/06



D3199-1F FLAT PATTERN



**D3199-1 BRACKET
MADE FROM D3199-1F**



RELEASED
2011-07-18
MP

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-X" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: D3199-1 = 0.11 lbs, D3199-3/4 = 0.26 lbs EACH

E	RE-DESIGNED D3199-3/4-3F PER CUSTOMER FEEDBACK TO OPTIMIZE FIT.	MB	11.07.11
D	RE-DESIGNED D3199-3/4-3F PER CUSTOMER FEEDBACK TO ELIMINATE BINDING OF DOOR ONCE BRACKETS ARE INSTALLED. REF: PAR11-78	MB	11.03.21
C	ADD -3/4 PART (SHEET 2-4)	HS	09.11.19
B	2.24 WAS 2.142; ADD FINISH; UPDATE DWG	CB	08.11.01
A	NEW ISSUE	CP	03.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>gp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>gp</i>		
CHECKED	<i>AP</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>AP</i>	D3199	SHEET 1 OF 4
APPROVED	<i>AP</i>	TITLE	SCALE
DE APPR.	<i>AP</i>	BRACKET	NTS
DATE	11.07.11	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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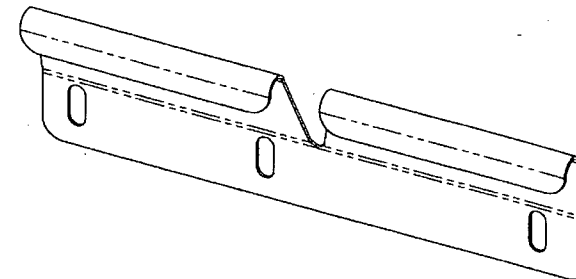
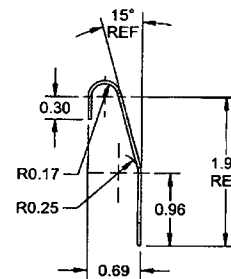
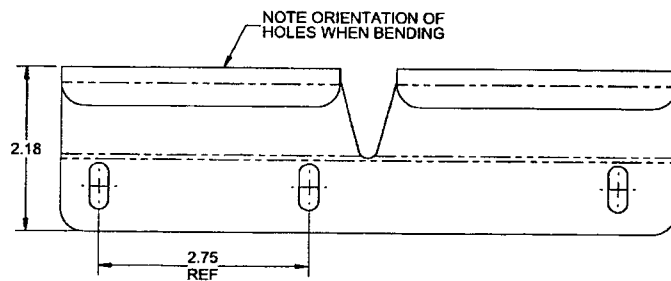
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D3199-3 BRACKET
MADE FROM D3199-3F

RELEASED
2011-07-18

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3199	REV. E
MFG. APPR.		SHEET 2 OF 4	
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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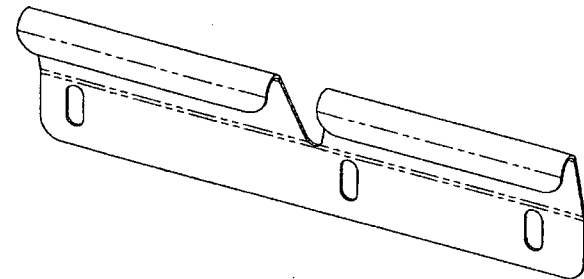
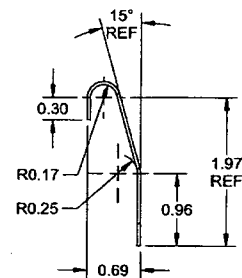
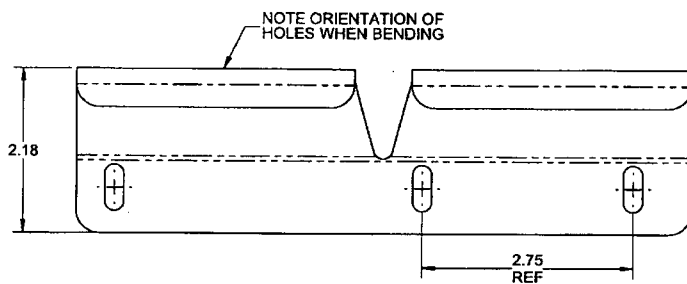
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77361



D3199-4 BRACKET
MADE FROM D3199-3F

RELEASED
2011-07-18

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3199	SHEET 3 OF 4
APPROVED		TITLE	SCALE
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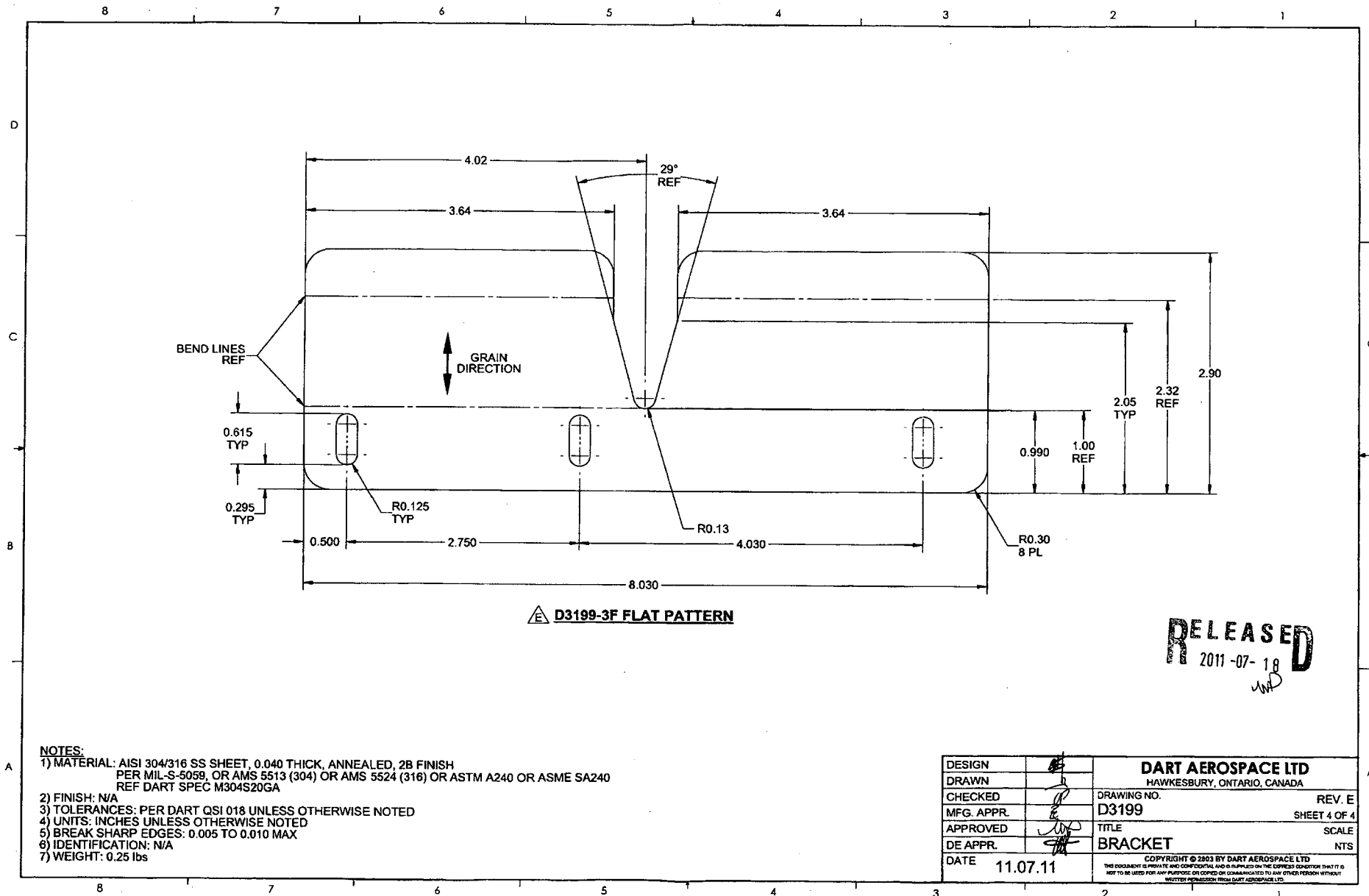
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